

Work Order ID 86087

June-20-12 12:58:35 PM

86087

Page 1

Item ID: D212-722-013

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Dzus Rail Brace

Stop ***NS2***

Start Date: 20/06/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 04/07/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/06/20 Tooling:

Run Start ***NR1***

QC:

Date: SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

DSI 9476

A

100

100

DC

Document Control

Memo

Photocopie DSI 9476 and labels per PPP D212-722-013

DAS 16 17/08/09

CHG001

MLJ 12-8-8

(2)

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

2

12/08/08 B

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Quality Control

Memo

0.00

DAS 16 17/08/09

(2)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86087

June-20-12 12:58:35 PM

86087

Page 2

Item ID: D212-722-013

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Dzus Rail Brace

Start Date: 20/06/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 04/07/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run Start *NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPP D212-722-013								
	Location: <u>124</u>								
	PPP rev: _____								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

12/8/13 *[Signature]*
MLJ 12/08/09

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 86087

86087

Parent Item: D212-722-013

D212-722-013

Parent Item Name: Dzus Rail Brace

Start Date: 20/06/2012

Required Date: 04/07/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP revA 11.06.21 new issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3986-1		Manufactured	No			110	Each	11.0000					
---------	--	--------------	----	--	--	-----	------	---------	--	--	--	--	--

See *D3986-1*

Angle

Location

Loc Qty

Loc Code

ST081

11

84644

11

D3986-3

Manufactured No

See *D3986-3*

Brace

Location

Loc Qty

Loc Code

ST103

8

71094

8

Qty per Kit: 2
Total Qty: 2
Qty Issued: JB
Date Issued: 12/08/08
Status:

Qty per Kit: 4
Total Qty: 4
Qty Issued: JB
Date Issued: 12/08/08
Status:

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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NO. 860081 M5

12/06/20

DART SERVICE INSTRUCTION
TO AMEND INSTALLATION INSTRUCTIONS IIN-D212-722 REV. AREF. TCCA STC: SH05-11
REF. FAA STC: SR02091NY
REF. EASA.IM.R.S.01181

The purpose of the Service Instruction is to provide instructions for the installation of the D212-722-013 Dzus Rail Brace Kit which has been developed to provide a fastening method for the center dzus rail when the D212-722-011 Avionics Riser Console is installed. The D212-722-013 kit has been added to all D212-722-011 kits at CHG 003 or later.

If the aircraft pedestal has been removed from the aircraft follow the instructions in Option 1. If the pedestal has not been removed from the aircraft follow instructions in Option 2 (Sheet 2).

The maximum weight of equipment installed in front of the D212-722-011 Avionics Riser Console using the D212-722-013 Kit is 40 lbs.

Option 1 - Install D212-722-013 Dzus Rail Brace Kit as follows if pedestal has been removed from aircraft:

Note: The existing PR35 center dzus rails will need to be removed and re-worked to the correct length in order to install the D212-722-013 Dzus Rail Brace Kit.

CAUTION: Alignment of the parts is critical to a successful installation. It is strongly recommended that the parts be clamped together before drilling and then clecoed together before riveting.

- 1) Remove the rivets securing the existing center PR35 dzus rails.
- 2) Remove the existing center dzus rail braces.
- 3) Clamp the D3986-1 angle, D3986-3 braces and PR35 dzus rail together as shown in Figure 1 (Sheet 3). The D3986-3 braces should be approximately centered between the existing dzus rails.
- 4) Install blanking plates (Figure 5, Sheet 7) to position the PR35 dzus rails in the correct position.
- 5) Transfer drill 9x $\varnothing 0.129$ (#30 drill) holes from PR35 dzus rail thru D3986-3 braces. See Figure 2, (Sheet 4), Note 1.
- 6) Deburr holes and reassemble using clecos.
- 7) Transfer drill 4x $\varnothing 0.129$ (#30 drill) holes from D3986-3 braces to D3986-1 angle. See Figure 2, (Sheet 4), Note 2.
- 8) Deburr holes and reassemble using clecos.
- 9) Transfer drill 4x $\varnothing 0.129$ (#30 drill) holes from aircraft pedestal to D3986-3 braces. See Figure 2, (Sheet 4), Note 3.
- 10) Deburr holes, dimple D3986-3 brace and aircraft pedestal and reassemble using clecos.
- 11) Transfer drill 4x $\varnothing 0.129$ (#30 drill) holes from D3986-1 angle to aircraft pedestal. See Figure 2, (Sheet 4), Note 4.
- 12) Deburr holes, dimple D3986-1 angle and aircraft pedestal and reassemble using clecos.
- 13) Re-install blanking plates (Figure 5, Sheet 7) and verify correct position of PR35 dzus rails.
- 14) Install MS20470AD4 and MS20426AD4 rivets as shown in Figure 2 (Sheet 4) in the same order as the holes were drilled, maintaining the PR35 dzus rail position.

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AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: D. Shepherd
D. SHEPHERD (DE # 02)

DATE: 11.06.01
CERT. NO.: SH05-11
ISSUE NO.: 1

A	NEW ISSUE		11.06.01
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.	N/A		
APPROVED			
DE APPR.			
DATE	11.06.01		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. DSI 9476	REV. A SHEET 1 OF 7
TITLE DZUS RAIL BRACE KIT	SCALE NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Option 2 - Install D212-722-013 Dzus Rail Brace Kit as follows if pedestal has not been removed from aircraft:

Note: The existing PR35 center dzus rails will need to be removed and re-worked to a correct length in order to install the D212-722-013 Dzus Rail Brace Kit.

CAUTION: Alignment of the parts is critical to a successful installation. It is strongly recommended that the parts be clamped together before drilling and then clecoed together before riveting.

- 1) Remove the rivets securing the PR35 center dzus rails from the existing dzus rail brace. Remove dzus rail.
- 2) Without removing it, trim the existing left dzus rail brace, as shown in Figure 4 (Sheet 6). Trim the existing right dzus rail brace 2.25" longer. See Note 1 Figure 4 (Sheet 6).
- 3) Trim D3986-3 braces so that when matched with the existing dzus rail braces the original D3986-3 length is maintained.
- 4) Clamp and cleco the D3986-1 angle, the trimmed D3986-3 braces and PR35 dzus rail together as shown in Figure 3 (Sheet 5).
- 5) Install blanking plates (Figure 5, Sheet 7) to position the PR35 dzus rails in the correct position.
- 6) Transfer drill $\varnothing 0.129$ (#30 drill) the necessary holes (4 typ) from PR35 dzus rail thru D3986-3 braces. See Figure 3, (Sheet 5), Note 1.
- 7) Deburr holes and reassemble using clecos.
- 8) Transfer drill 4x $\varnothing 0.129$ (#30 drill) holes from D3986-3 braces to D3986-1 angle. See Figure 3, (Sheet 5), Note 2.
- 9) Deburr holes and reassemble using clecos.
- 10) Transfer drill 4x $\varnothing 0.129$ (#30 drill) holes from D3986-1 angle to aircraft console. See Figure 3, (Sheet 5), Note 3.
- 11) Deburr holes, dimple D3986-1 angle and aircraft console and reassemble using clecos.
- 12) Re-install blanking plates (Figure 5, Sheet 7) and verify correct position of PR35 dzus rails
- 13) Install MS20470AD4 and MS20426AD4 rivets as shown in Figure 3 (Sheet 5) in the same order as the holes were drilled, maintaining the PR35 dzus rail position.

WEIGHT AND BALANCE

Compliance with this DSI has no effect on the aircraft weight and balance.

PARTS LIST

QTY. -013	PART NUMBER	DESCRIPTION
X	D212-722-013	DZUS RAIL BRACE KIT
1	D3986-1	ANGLE
2	D3986-3	BRACE

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

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BY:

D. SHEPHERD (DE # 02)

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MFG. APPR.	N/A	DSI 9476	SHEET 2 OF 7
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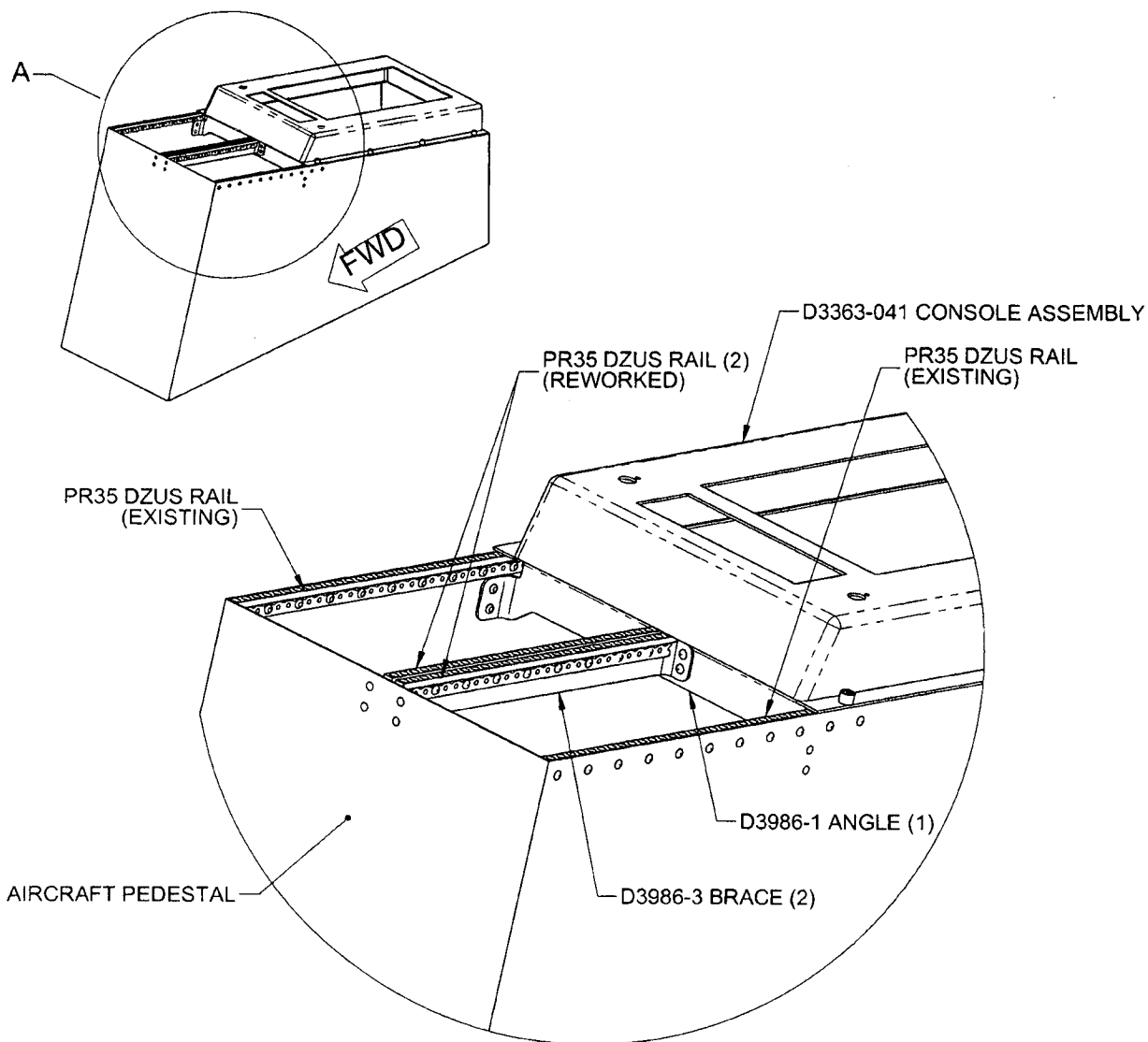
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NOTE: Date & initial all entries



DETAIL A

FIGURE 1: D212-722-013 DZUS RAIL BRACE INSTALLATION

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*81008
X3008*

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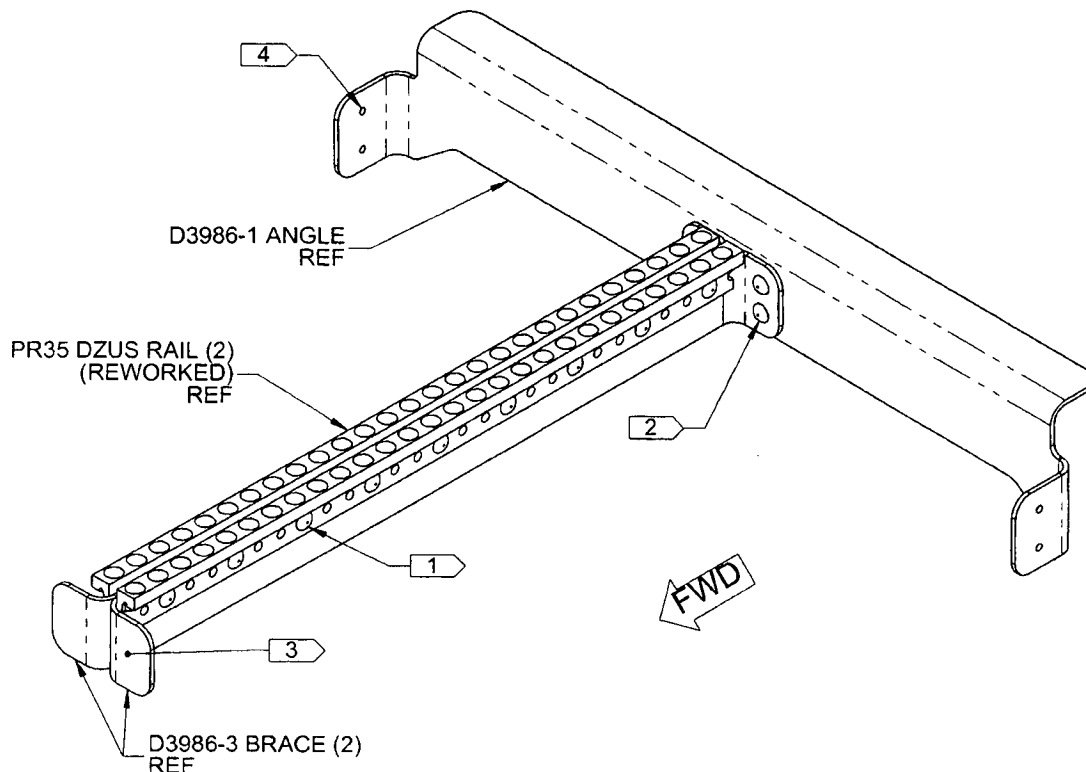
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



- 1) CONFIRM THAT DZUS RAIL AND BRACE ARE IN CORRECT POSITION AND TRANSFER DRILL $\varnothing 0.129$ (#30 DRILL) FROM PR35 DZUS RAIL THRU D3986-3 BRACES. INSTALL MS20470AD4 RIVETS, 9 PL TYP
- 2) CONFIRM THAT DZUS RAIL AND BRACE ARE IN CORRECT POSITION AND TRANSFER DRILL 4X $\varnothing 0.129$ (#30 DRILL) HOLES FROM D3986-3 BRACE TO D3986-1 ANGLE. INSTALL MS20470AD4 RIVETS, 4 PL
- 3) CONFIRM THAT DZUS RAIL AND BRACE ARE IN CORRECT POSITION AND TRANSFER DRILL 4X $\varnothing 0.129$ (#30 DRILL) FROM AIRCRAFT CONSOLE TO D3986-3 BRACES. DIMPLE D3986-3 BRACES AND INSTALL MS20426AD4 RIVETS, 4 PL.
- 4) CONFIRM THAT DZUS RAIL AND BRACE ARE IN CORRECT POSITION AND TRANSFER DRILL 4X $\varnothing 0.129$ (#30 DRILL) FROM D3986-1 ANGLE TO AIRCRAFT CONSOLE. DIMPLE D3986-1 ANGLE AND AIRCRAFT CONSOLE AND INSTALL MS20426AD4 RIVETS, 4 PL

FIGURE 2: D212-722-013 DZUS RAIL BRACE INSTALLATION - OPTION 1
(PEDESTAL REMOVED FROM AIRCRAFT)

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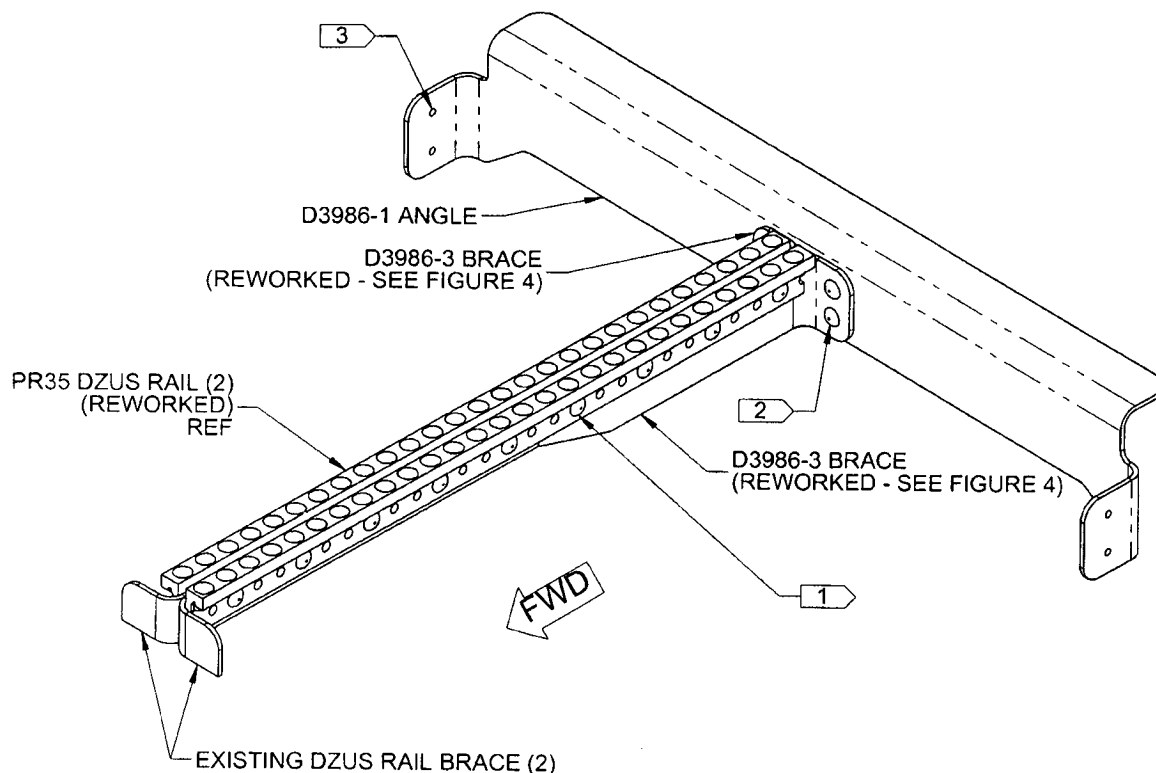
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries



- 1) CONFIRM THAT DZUS RAIL AND BRACE ARE IN CORRECT POSITION AND TRANSFER DRILL (4 PL TYP) $\varnothing 0.129$ (#30 DRILL) FROM PR35 DZUS RAIL THRU D3986-3 BRACES. INSTALL MS20470AD4 RIVETS, 9 PL TYP
- 2) CONFIRM THAT DZUS RAIL AND BRACE ARE IN CORRECT POSITION AND TRANSFER DRILL 4X $\varnothing 0.129$ (#30 DRILL) HOLES FROM D3986-3 BRACE TO D3986-1 ANGLE. INSTALL MS20470AD4 RIVETS, 4 PL
- 3) CONFIRM THAT DZUS RAIL AND BRACE ARE IN CORRECT POSITION AND TRANSFER DRILL 4X $\varnothing 0.129$ (#30 DRILL) FROM D3986-1 ANGLE TO AIRCRAFT CONSOLE. DIMPLE D3986-1 ANGLE AND AIRCRAFT CONSOLE AND INSTALL MS20426AD4 RIVETS, 4 PL

FIGURE 3: D212-722-013 DZUS RAIL BRACE INSTALLATION - OPTION 2
(PEDESTAL NOT REMOVED FROM AIRCRAFT)

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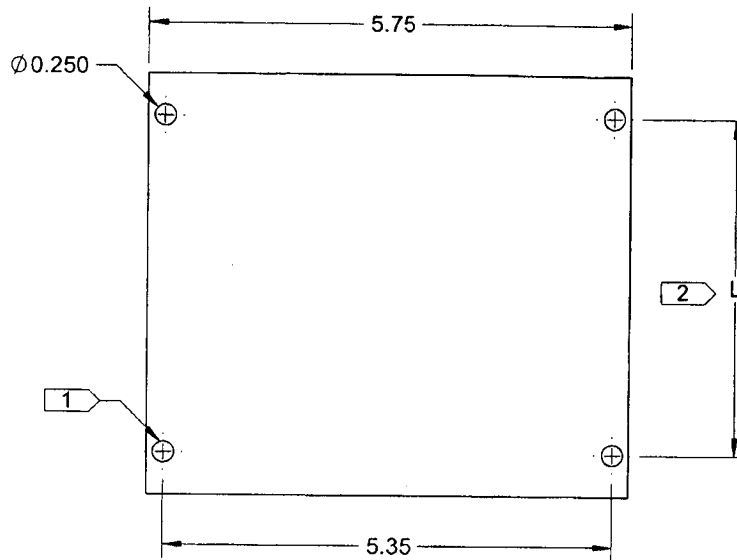
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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- 1) INSTALL DZUS FASTENERS, 4 PL TYP
- 2) DIMENSION "L" IS MIN 4". MUST BE DIVISIBLE BY 0.375

FIGURE 5: BLANKING PLATE

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Option 2 - Install D212-722-013 Dzus Rail Brace Kit as follows if pedestal has not been removed from aircraft:

REFERENCE ONLY

Note: The existing PR35 center dzus rails will need to be removed and re-worked to a correct length in order to install the D212-722-013 Dzus Rail Brace Kit.

CAUTION: Alignment of the parts is critical to a successful installation. It is strongly recommended that the parts be clamped together before drilling and then clecoed together before riveting.

- 1) Remove the rivets securing the PR35 center dzus rails from the existing dzus rail brace. Remove dzus rail.
- 2) Without removing it, trim the existing left dzus rail brace, as shown in Figure 4 (Sheet 6). Trim the existing right dzus rail brace 2.25" longer. See Note 1 Figure 4 (Sheet 6).
- 3) Trim D3986-3 braces so that when matched with the existing dzus rail braces the original D3986-3 length is maintained.
- 4) Clamp and cleco the D3986-1 angle, the trimmed D3986-3 braces and PR35 dzus rail together as shown in Figure 3 (Sheet 5).
- 5) Install blanking plates (Figure 5, Sheet 7) to position the PR35 dzus rails in the correct position.
- 6) Transfer drill $\varnothing 0.129$ (#30 drill) the necessary holes (4 typ) from PR35 dzus rail thru D3986-3 braces. See Figure 3, (Sheet 5), Note 1.
- 7) Deburr holes and reassemble using clecos.
- 8) Transfer drill 4x $\varnothing 0.129$ (#30 drill) holes from D3986-3 braces to D3986-1 angle. See Figure 3, (Sheet 5), Note 2.
- 9) Deburr holes and reassemble using clecos.
- 10) Transfer drill 4x $\varnothing 0.129$ (#30 drill) holes from D3986-1 angle to aircraft console. See Figure 3, (Sheet 5), Note 3.
- 11) Deburr holes, dimple D3986-1 angle and aircraft console and reassemble using clecos.
- 12) Re-install blanking plates (Figure 5, Sheet 7) and verify correct position of PR35 dzus rails
- 13) Install MS20470AD4 and MS20426AD4 rivets as shown in Figure 3 (Sheet 5) in the same order as the holes were drilled, maintaining the PR35 dzus rail position.

WEIGHT AND BALANCE

Compliance with this DSI has no effect on the aircraft weight and balance.

PARTS LIST

QTY. -013	PART NUMBER	DESCRIPTION
X	D212-722-013	DZUS RAIL BRACE KIT
1	D3986-1	ANGLE
2	D3986-3	BRACE

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
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APPROVED

BY:

D. SHEPHERD (DE # 02)

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